



### RECOMMENDED PARAMETERS

#### Fabric Types



100% Cotton, blends or synthetic fabrics.

#### Mesh



Count: 180-305T/in (72-120T/cm) for Clear, 86-230T/in (34-90T/cm) for White  
Tension: 18-35n/cm<sup>3</sup>

#### Squeegee



60-90-60  
Profile: sharp, square  
Stroke: x1 stroke, medium speed  
Angle: 10-15%

#### Stencil



Water Resistant Emulsion  
Off Contact: 1/16" (2mm)  
Emulsion Over Mesh: 15-20%

#### Flash & Cure



Flash: 2-4 sec. at 180°-200°F (80°-90°C)  
Cure: 90 sec. at 320°F/160°C (Cotton), 90 sec. at 305°F/151°C (Polyester)\*

#### Pigment Loading



Not recommended

#### Aquarius™ Additives



Aquarius™ Retarder 0.5-1% (white only)

#### Storage



Store in sealed containers 12 months from manufacture >40°F (5°C) <77°F (25°C)

#### Clean Up



Water & mild detergent

#### Health & Safety



SDS: [www.avient.com/resources/safety-data-sheets](http://www.avient.com/resources/safety-data-sheets) or contact your local CSR

Aquarius™ Digital Hybrid ink System consists of a high opacity Digital White and Digital Matte Clear. Designed to provide maximum opacity and an excellent surface to receive a digitally printed image. Resulting prints will be soft hand and flexible with excellent wash performance.

### HIGHLIGHTS

- Used in conjunction with a hybrid digital machine
- Excellent color yield and print definition
- Stays open in the screen

### PRINTING TIPS

- White can be used as stand alone white or as an under-base for additional white and clear
- For best performance use 180-305T/in (72-120T/cm) mesh for Digital Matte Clear and 86-230T/in (34-90T/cm) mesh for Digital White
- Print with 1/16" or 2mm off contact
- Keep platens cool to avoid white ink aging (130-140°F / 54-60°C)
- Clean the stencil area when stopped to prevent screen blockages
- (\*) Cotton prints should be cured at 320°F/160°C and polyester prints at 305°F/151°C for 90 seconds, but taking into account the additional load of digital ink we suggest to increase the dwell time in the dryer to 120 seconds
- Test all prints for print durability before starting the production run

### COMPLIANCE

- Water based, non PVC, non phthalate
- Visit [www.avient.com/products/screen-printing-inks/zodiac-aquarius](http://www.avient.com/products/screen-printing-inks/zodiac-aquarius) for more information

### PRECAUTIONS

- The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications



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